

De/s
UserMonday, 9/10/2007 1:31:26 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 34512		
Estimate Number	: 10278		
P.O. Number	: <u>N/A</u>	Part Number	: D3121141
This Issue	: 9/10/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3121 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 33694	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 9/30/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	<u>22</u> Um: Each
Comment	: Est Rev: Pick: A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B1000X02000 17-4 SS Bar



Comment: Qty.: 0.5775 f(s)/Unit Total : 13.8600 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000)

Identify for D3121-111

Batch: M103089X18PCS M14421X6PCSSL 07/10/04

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

SL 07/10/04

3.0 HAAS HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

SL/JF 07/11/03Pro22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL/JF 07/11/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/11/15
 QA: N/C Closed: _____ Date: _____

NCR: <u>34512</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/31	3	1 part is scrap because part when out of the fixture.	[Signature]	Scrap replace part B No replace N/A	J.F. 07/10/31		[Signature]	QA 1031
07/10/31	3	1 part thickness is .002" under minimum tolerance. A.C. Part moved in the vice when facing.	LE 07.11.13 QS1042	Acceptable. Groove depth measured to be 0.029" and calculation re-done per stress report. Drawing revised to change groove tolerance.	J.F. 07/10/31	[Signature]	LE 07.11.13 QS1042	[Signature] 07.11.13

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:31:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34512

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PLM/07-11-03 (22)

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-21

Bolt B33503

X 18PCS

B 34522 X 4PCS

J.L./J.F. 07/11/03

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-241 Bearing Ass

B34523

J.L./J.F. 07/11/03

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

J.L./J.F. 07/11/03

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PLM/07-11-04 (22)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST.233

(22) 07/11/05 18

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



U 07-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34512
Description: Bracket		Part Number:	D3121-111
Inspection Dwg: D3121 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	Ø 0.393"	✓			
0.75	+/-0.030	0.753"	✓			
0.375	+/-0.010	0.375"	✓			
2.14	+/-0.030	2.142"	✓			
0.950	+/-0.010	0.955"	✓			
0.600	+/-0.010	0.600"	✓			
1.96	+/-0.030	1.968"	✓			
0.280	+/-0.010	0.284"	✓			
3.330	+/-0.010	3.305"	✓			
3.630	+/-0.010	3.634"	✓			
R0.25	+/-0.030	R 0.250"	✓			
R0.375	+/-0.010	R 0.375"	✓			
* Ø0.201	+0.005/-0.000	Ø 0.201"	✓			
0.100	+/-0.010	0.100"	✓			
6.18	+/-0.030	6.170"	✓			
5.89	+/-0.030	5.895"	✓			
0.080	+/-0.010	0.083"	✓			
0.300	+/-0.010	0.300"	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R 0.25"	✓			
0.130	+/-0.010	0.125"	✓			
0.381	+/-0.010	0.373"	✓			
0.201"	+/-0.010	0.202"	✓			
0.400	+/-0.010	0.398"	✓			
0.580	+/-0.010	0.575"	✓			
100°	+/-0.1°	100°	✓			
0.032"	+/-0.010	0.032"	✓			

Measured by: J.F.	Audited by: S.F.	Prototype Approval:	N/A
Date: 07/10/31	Date: 07/10/31	Date:	N/A

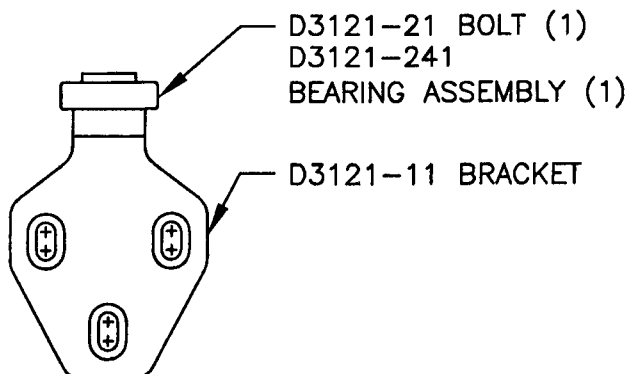
Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	



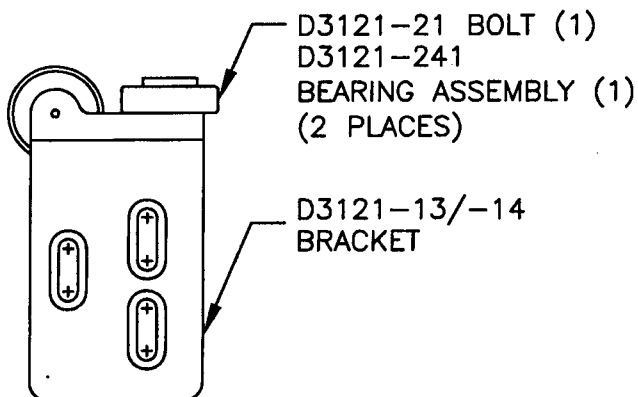
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		D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

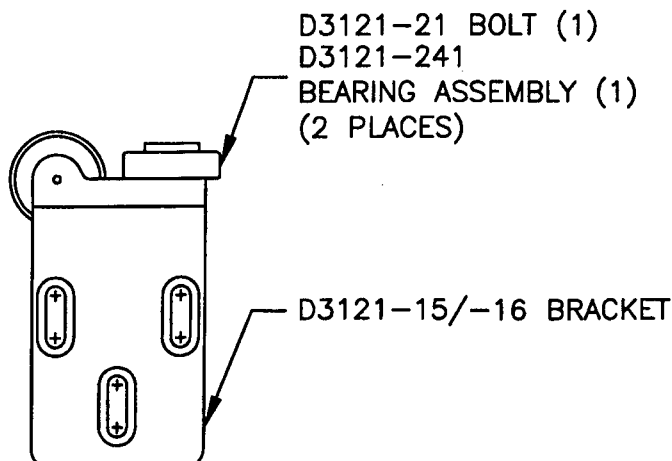
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

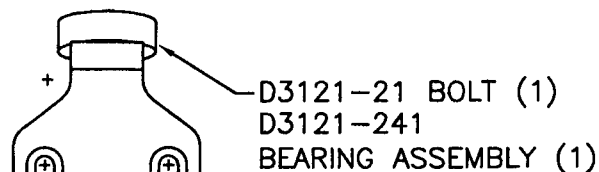
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DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2

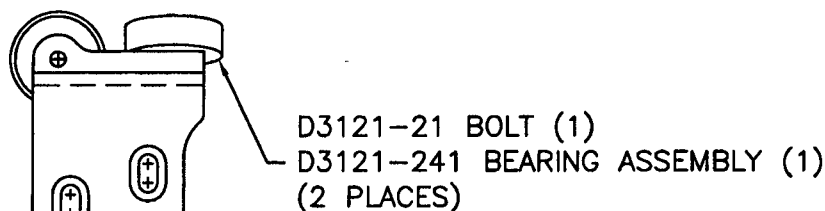


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

RELEASED

06-06-02

D3121-111 BRACKET



D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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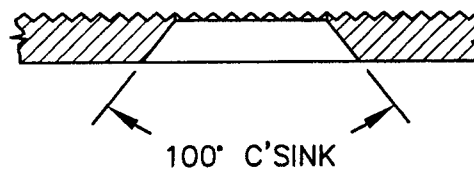
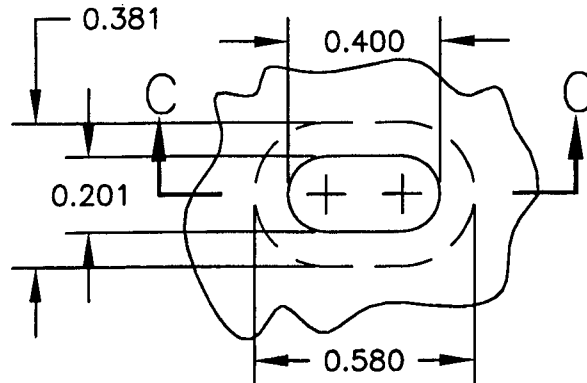
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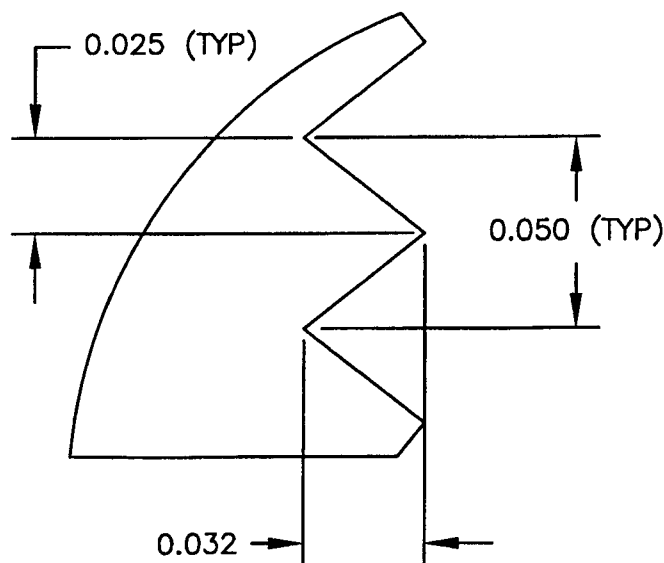
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. D SHEET 3 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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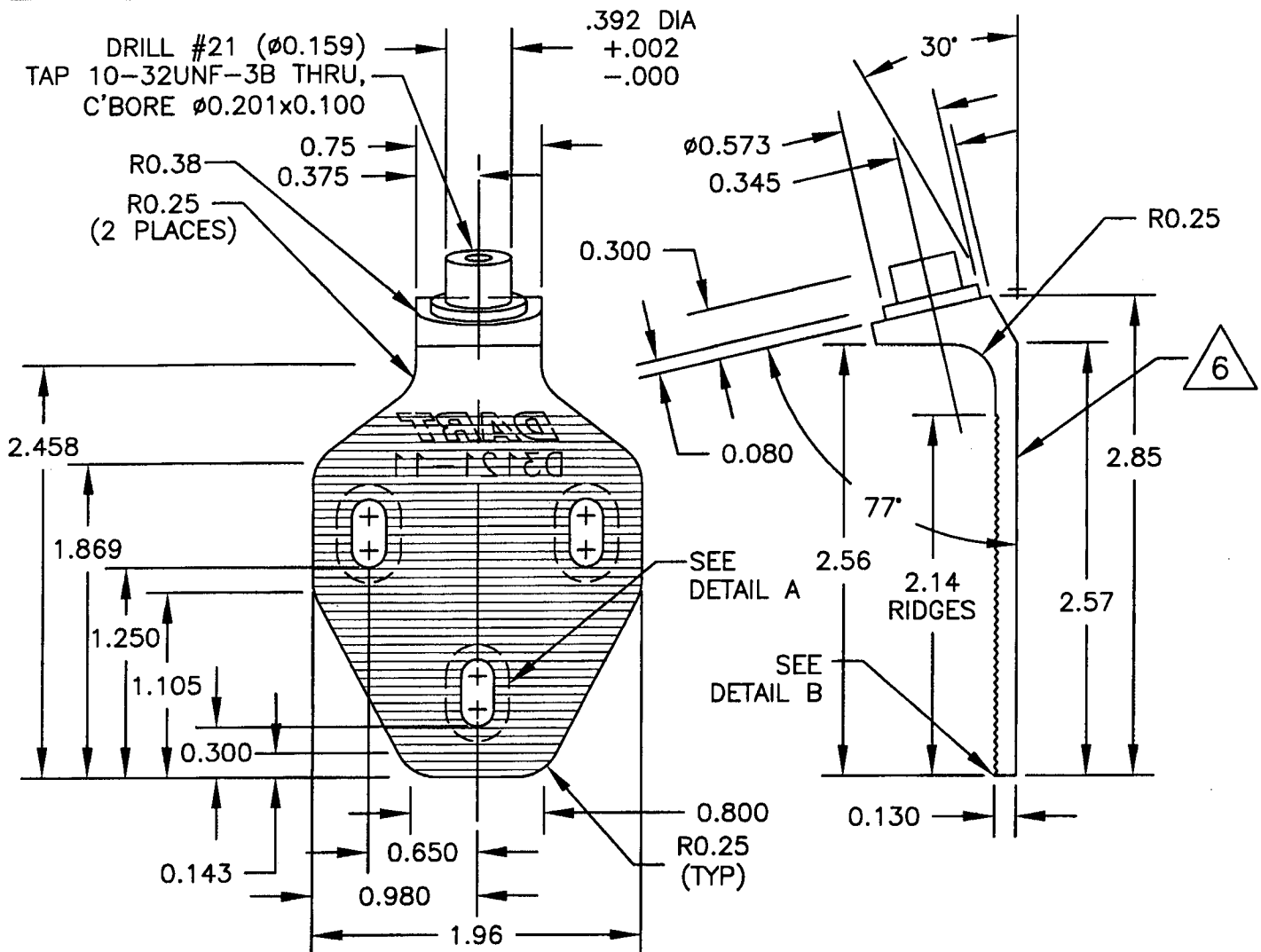
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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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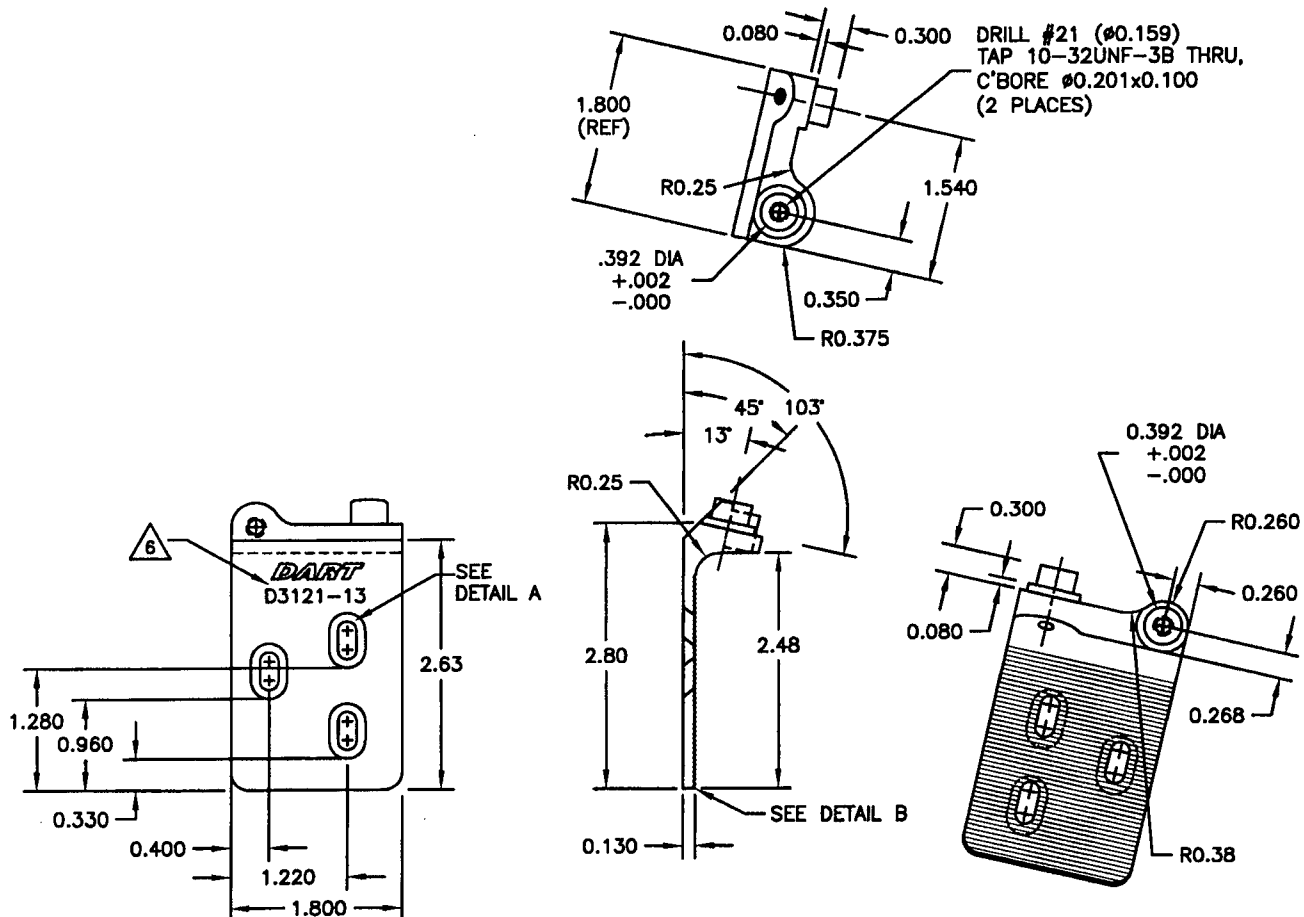
06.06.02 JH

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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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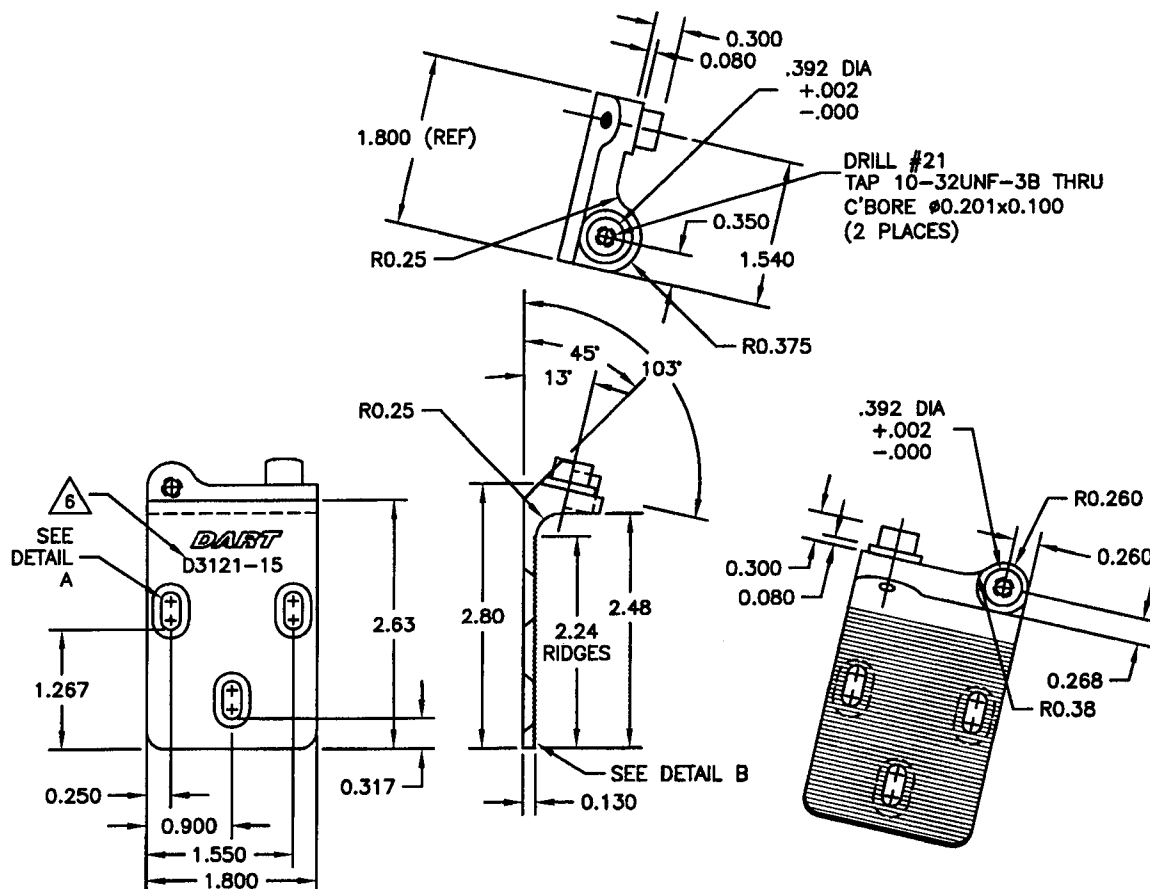
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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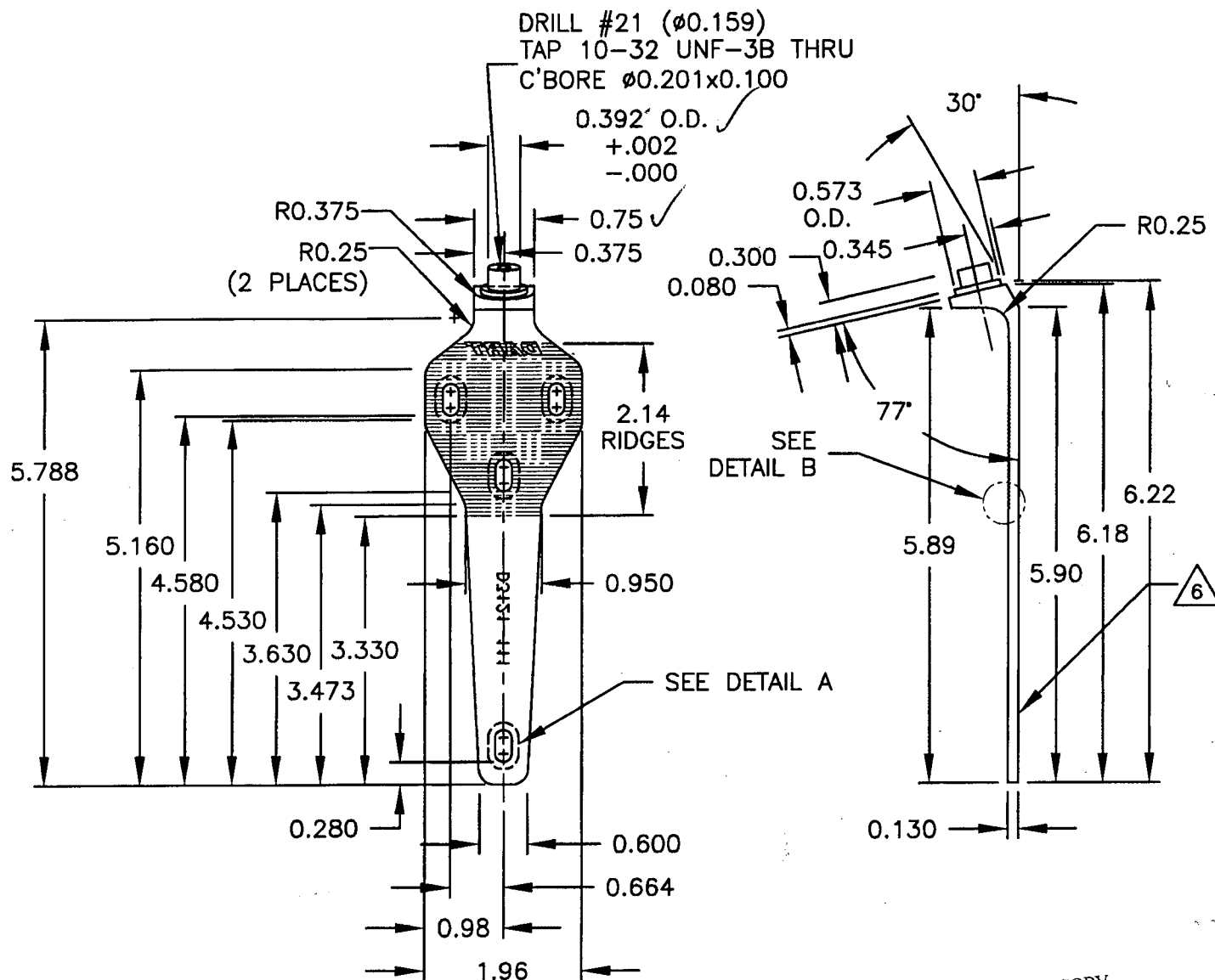
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. D SHEET 7 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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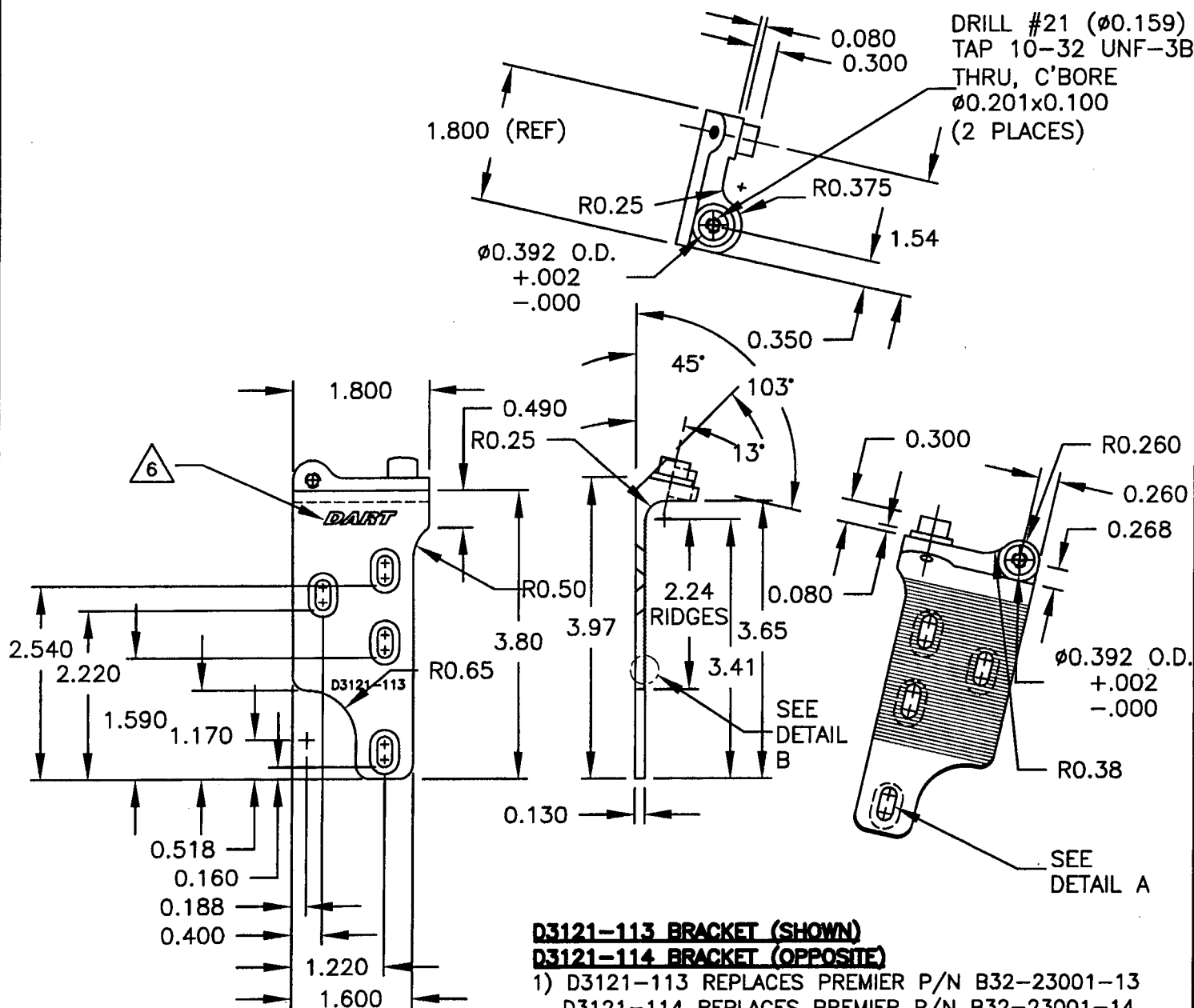
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CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 8 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2

**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14

- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

RELEASE

06.06.02

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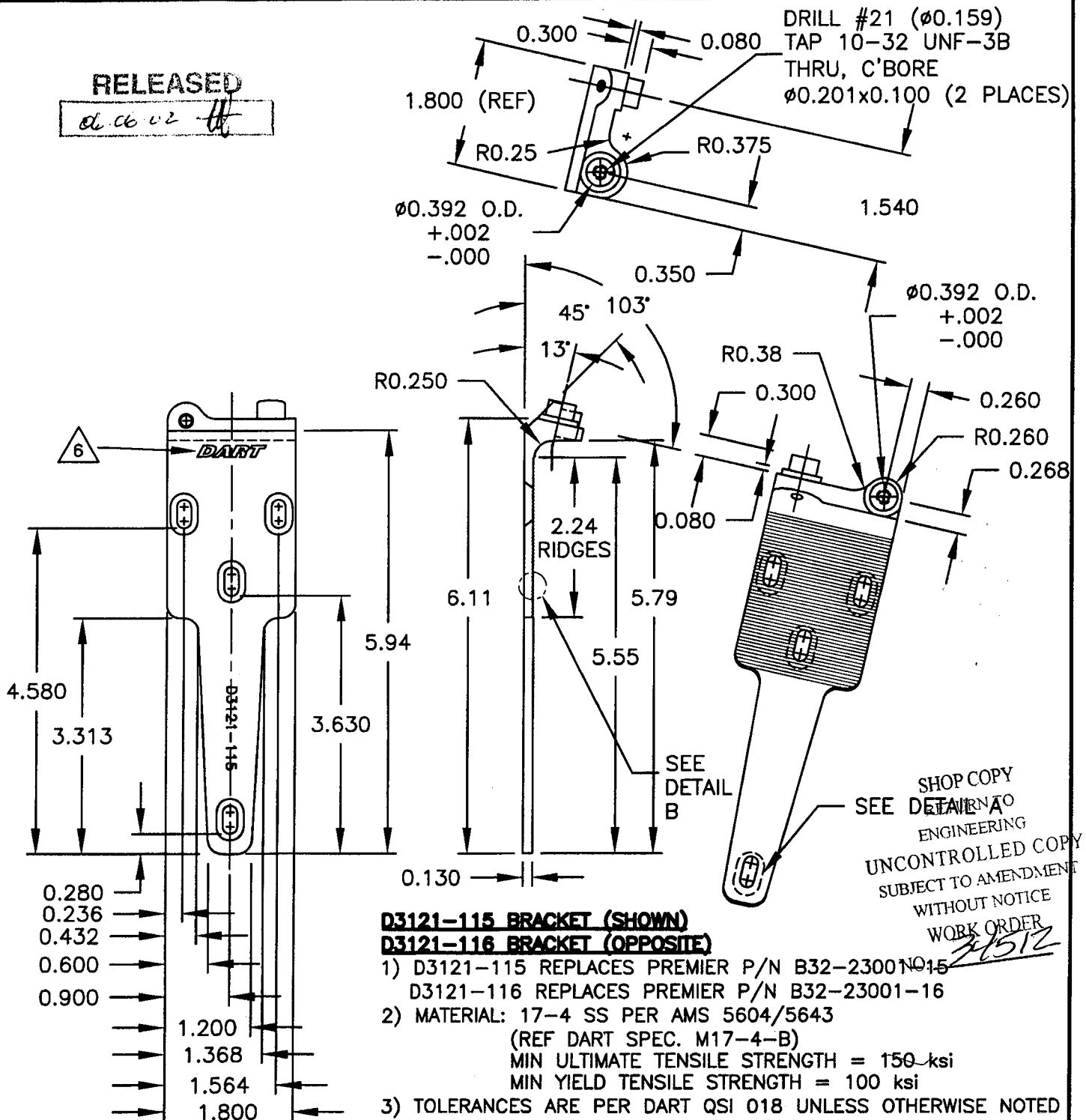
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED

04.06.02 J.H.

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

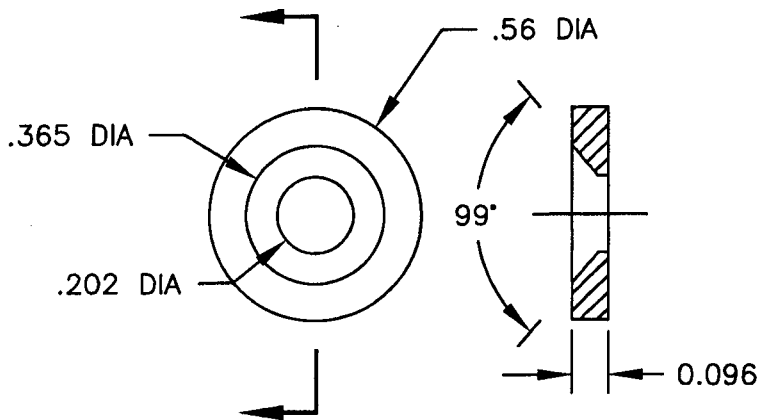
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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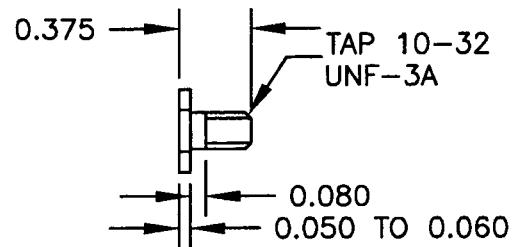
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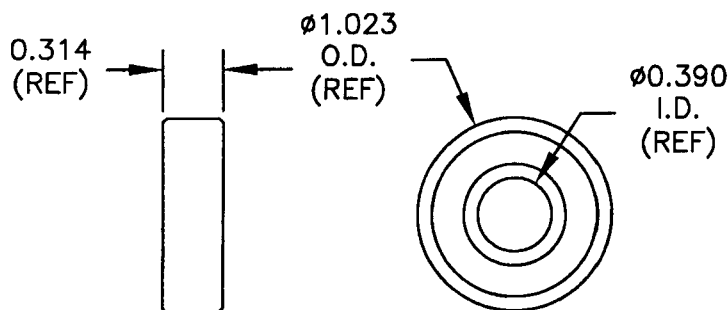
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CHECKED JH	APPROVED JH	DRAWING NO. D3121	REV. D SHEET 10 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

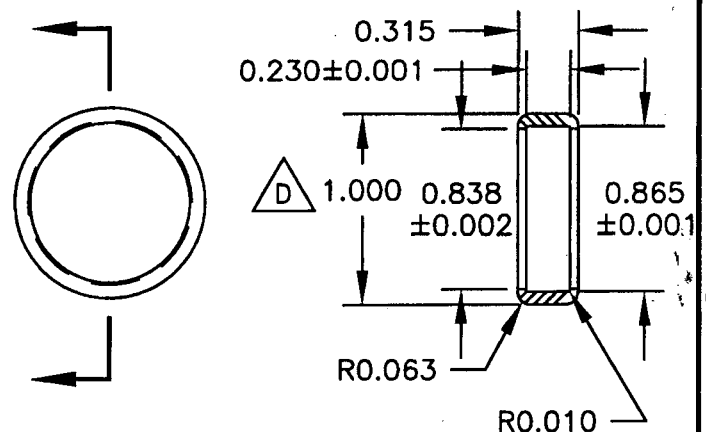
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-21 BOLT (SCALE 1:1)**

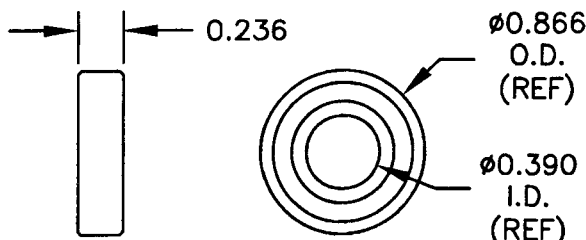
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

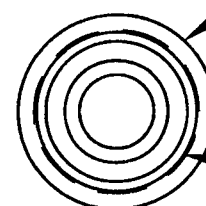
**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.06.02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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D3121-23
BEARING

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